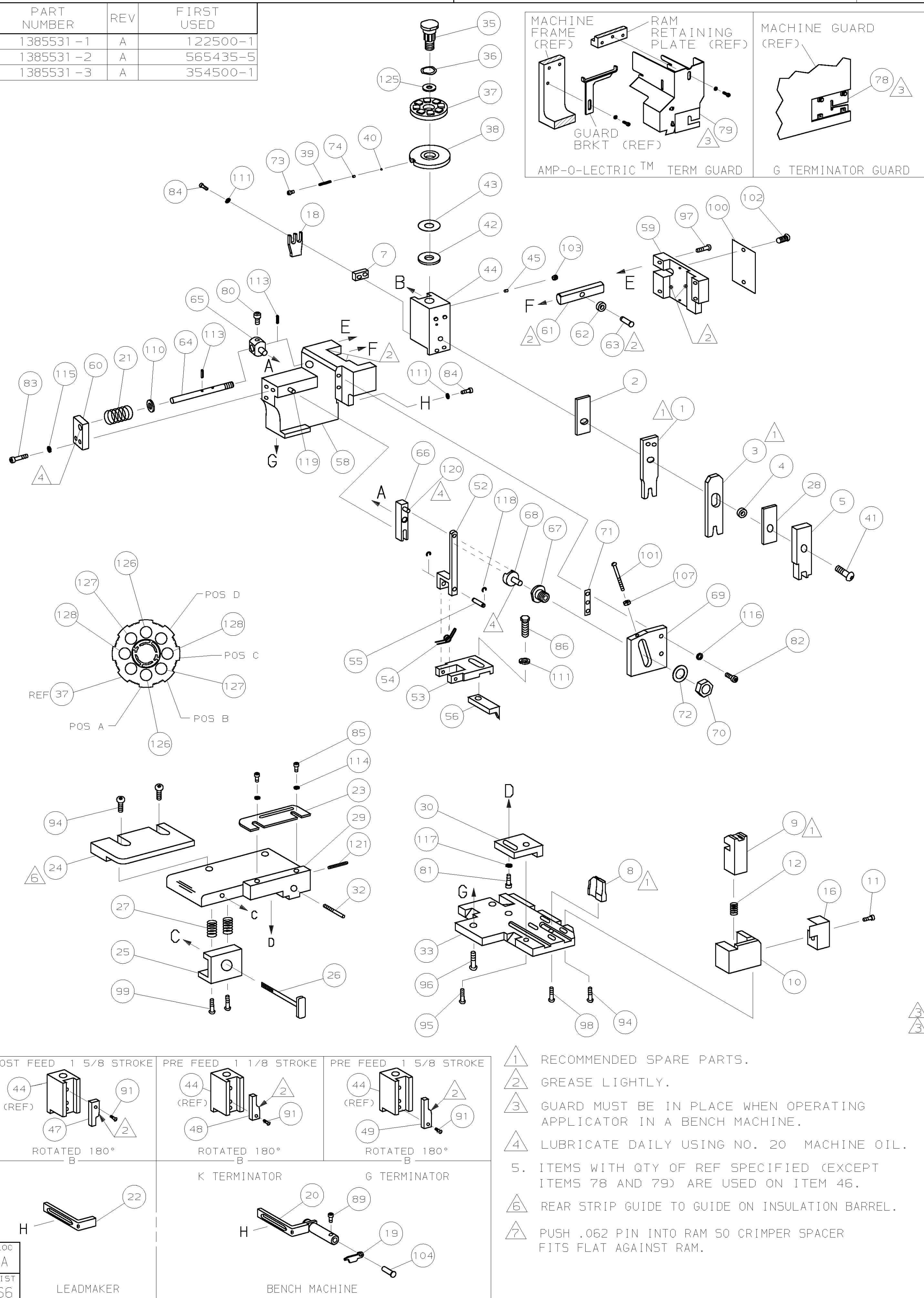
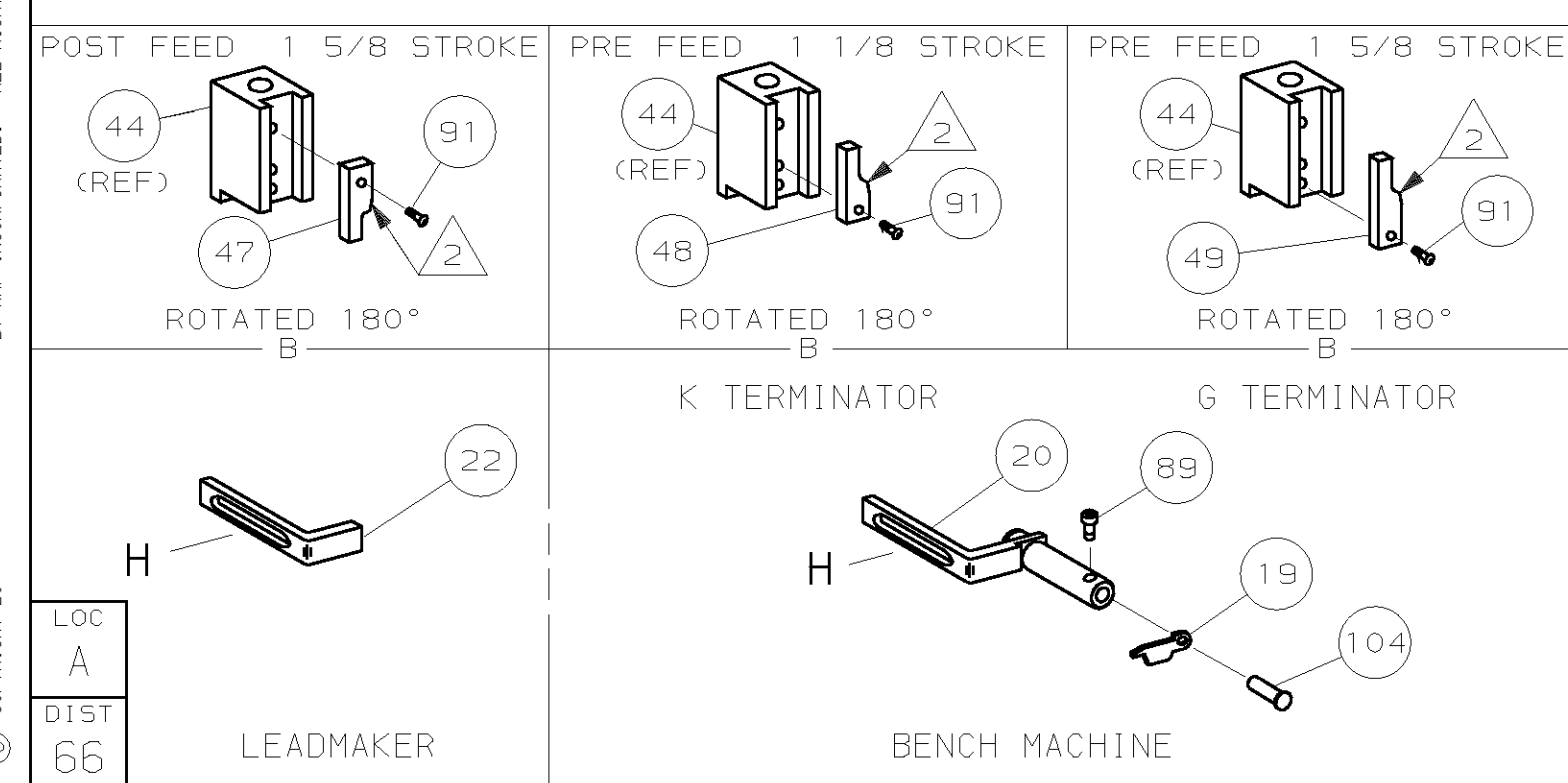


PART NUMBER	REV	FIRST USED
1385531-1	A	122500-1
1385531-2	A	565435-5
1385531-3	A	354500-1

THIS DRAWING IS A CONTROLLED DOCUMENT.



- ① RECOMMENDED SPARE PARTS.
- ② GREASE LIGHTLY.
- ③ GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN A BENCH MACHINE.
- ④ LUBRICATE DAILY USING NO. 20 MACHINE OIL.
- ⑤ ITEMS WITH QTY OF REF SPECIFIED (EXCEPT ITEMS 78 AND 79) ARE USED ON ITEM 46.
- ⑥ REAR STRIP GUIDE TO GUIDE ON INSULATION BARREL.
- ⑦ PUSH .062 PIN INTO RAM SO CRIMPER SPACER FITS FLAT AGAINST RAM.



TERMINAL NAME: SOCKET			
AMP TERM PN	MFR TERM PN		
1572209	M22-3040022		
PAD LTR	CRIMP HEIGHT	WIRE SIZE	
A	.024 ±.002 [0.61 ±0.05mm]	24	
B	.022 ±.002 [0.56 ±0.05mm]	26	
C	.020 ±.002 [0.51 ±0.05mm]	28	
D	NOT	USED	
CRIMP	SIZE	TYPE	RANGE
WIRE	.042 [1.07mm]	F	28-24
INSUL	.055 [1.40mm]	F	.046 MAX

WIRE STRIP LENGTH	TERM APPL	SPEC	FEED	APPL INSTRUCTION	SET UP GAGE	LAYOUT								
.067-.084	NONE		.217	408-8040	458637-1	L2758								
QTY	REF	REF	REF	REF	REF	REF	REF	REF	REF	REF	REF	REF	REF	REF
2	2	2	-	C	7-354779-1	PIN, WIRE DISC (.3345)C	129							
2	2	2	-	C	6-354779-7	PIN, WIRE DISC (.3325)B	127							
2	2	2	-	C	6-354779-3	PIN, WIRE DISC (.3305)A	126							
1	1	1	-	A	986950-1	WASHER, FLAT PRECISION	125							
1	1	1	-	A	217238-1	GENERAL INSTRUCTION PACKAGE	124							
1	1	1	-	-	4088040	SF APPL INST 408-8040	123							
							122							
1	1	1	-	A	4-21028-0	PIN, SLT SPR (Ø.093x.75)ST GDE PL	121							
REF	REF	REF	-	A	1-21030-1	PIN, DOWEL (Ø.187x.50)LEVER	120							
REF	REF	REF	-	A	1-21030-6	PIN, DOWEL (Ø.187x1.25)HOUSING	119							
REF	REF	REF	-	A	21045-3	RING, RET "C" (Ø.187)FD FING PIN	118							
1	1	1	-	A	21024-5	WASHER, LOCK (#10)ADJ BLK	117							
REF	REF	REF	-	A	21024-5	WASHER, LOCK (#10)ADJ PLATE	116							
REF	REF	REF	-	A	21024-5	WASHER, LOCK (#10)FEED GDE ROD	115							
2	2	2	-	A	21024-2	WASHER, LOCK (#4)FRONT STP GUIDE	114							
REF	REF	REF	-	A	5-21028-1	PIN, SLT SPR (Ø.125x.50)ADJ ROD	113							
							112							
4	4	4	-	A	21024-4	WASHER, LOCK (#8)STRIPPER	111							
REF	REF	REF	-	A	21899-4	WASHER, FLAT (Ø5/16) SCREW ADJ	110							
							109							
REF	REF	REF	-	A	21068-5	NUT, HEX (6-32)FEED ADJ	107							
							106							
							105							
1	1	-	-	A	992031-1	PIN, CLEVIS	104							
1	1	1	-	A	21009-2	SCR, SKT 5ET (1/4-20x.25 LW)RAM	103							
2	2	2	-	A	21017-2	SCR, DRIVE (#2x.19) ID PLATE	102							
REF	REF	REF	-	A	6-23715-5	SCR, PAN HD (6-32x1.50)FEED ADJ	101							
1	1	1	-	B	461264-1	PLATE, IDENTIFICATION	100							
2	2	2	-	A	3-21002-0	SCR, BHC (10-32x.88)DRAG	99							
1	1	1	-	A	22733-8	SCR, BHC (8-32x.38 LW)ANVIL	98							
REF	REF	REF	-	A	2-21002-9	SCR, BHC (10-32x.75)CAP	97							
REF	REF	REF	-	A	2-22733-8	SCR, BHC (1/4-20x.62)HOUSING	96							
REF	REF	REF	-	A	2-21002-7	SCR, BHC (10-32x.50)56 ADJ BLOCK	95							
4	4	4	-	A	2-21002-2	SCR, BHC (8-32x.50)TERM H DWN	94							
							93							
							92							
1	1	1	-	A	1-21002-7	SCR, BHC (6-32x.38)CAM	91							
							90							
1	1	-	-	A	7-21000-9	SCR, SHC (4-40x.19)STRIPPER	89							
							88							
2	2	2	-	A	2-21000-5	SCR, SKT CAP (8-32 x.25)	87							
1	1	1	-	A	2-22603-0	SCR, HEX HD (8-32x.31)FEED FINGER	86							
2	2	2	-	A	1-21000-3	SCR, SHC (4-40x.25)FR ST GUIDE	85							
1	1	1	-	A	2-21000-7	SCR, SHC (8-32x.50)STRIPPER	84							
REF	REF	REF	-	A	3-21000-7	SCR, SHC (10-32x.75)FEED ROD GD	83							
REF	REF	REF	-	A	3-21000-6	SCR, SHC (10-32x.62)FD ADJ BLK	82							
1	1	1	-	A	3-21000-4	SCR, SHC (10-32x.38)56 ADJ BL	81							
REF	REF	REF	-	A	3-21000-4	SCR, SHC (10-32x.38)PIVOT BLK	80							
-	REF	-	-	B	455749-1	GUARD, WINDOW	79							
REF	-	-	-	B	679532-1	INSERT, GUARD	78							
							77							
							76							
							75							
1	1	1	-	A	690603-1	SPRING, ASSIST	74							
1	1	1	-	A	23030-1	SCR, SHC (6-32x.25 SL)INS DISC	73							
REF	REF	REF	-	A	458109-1	WASHER, SPECIAL	72							
REF	REF	REF	-	A	690517-1	SPACER	71							
							70							
							69							
							68							
							67							
							66							
							65							
							64							
							63							
							62							
							61							
							60							
							59							
							58							
							57							
							56							
1	1	1	-	B	690542-2	PAWL, FEED	55							
REF	REF	REF	-	B	240624-1	PIN, FEED FINGER	54							
REF	REF	REF	-	B	691499-1	SPRING, FEED FINGER	53							
REF	REF	REF	-	B	690541-1	HOLDER, FEED FINGER	52							
REF	REF	REF	-	A	455679-1	LEVER, TERMINAL FEED ARM	51							
							50							
1	-	-	-	B	690602-6	CAM, PRE-FEED 1 5/8 ST	49							
-	1	-	-	B	690602-5	CAM, PRE-FEED 1 1/8 ST	48							
-	-	1	-	B	690501-4	CAM, POST-FEED 1 5/8 ST	47							
1	1	1	-	B	459456-1	APPLICATOR, BASIC (SUBASSY)	46							
1	1	1	-	A	690191-1	PLUG, NYLON	45							
1	1	1	-	C	455673-3	RAM	44							
1	1	1	-	A	690125-1	WASHER, LAMINATED	43							
1	1	1	-	A	690124-1	WASHER, RAM	42							
1	1	1	-	A	7-21002-9	BOLT, CRIMPER (5/16x1.00)	41							
1	1	1	-	A	23241-6	BALL, STEEL	40							
1	1	1	-	A	690170-1	SPRING, COMPRESSION	39							
1	1	1	-	C	690142-1	DISC, INSULATION	38							
1	1	1	-	D	354777-1	WIRE DISC, PLASTIC	37							
1	1	1	-	A	22480-5	WASHER, SPRING	36							
1	1	1	-	B	690212-1	POST, RAM	35							
							34							
REF	REF	REF	-	D	455675-1	PLATE, BASE	33							
1	1	1	-	A	690432-3	SCREW, ADJUSTMENT	32							
							31							
REF	REF	REF	-	B	455689-1	BLOCK, STRIP GUIDE ADJ	30							
1	1	1	-	C	455671-1	PLATE, STRIP GUIDE	29							
1	1	1	-	C	1-455888-0	SPACER, FRONT SHEAR DEP	28							
2	2	2	-	A	1-22284-0	SPRING, DRAG	27							
1	1	1	-	B	690546-1	LEVER, DRAG RELEASE	26							
1	1	1	-	B	240792-1	DRAG, TERMINAL	25							
1	1	1	-	D	2-90765-6	GUIDE, STRIP (REAR)	24							
1	1	1	-	A	690438-1	GUIDE, STRIP (FRONT)	23							
-	-	1	-	B	690472-2	STRIPPER	22							
REF	REF	REF	-	A	4-22284-9	SPRING, FEED RETURN	21							
1	1	-	-	A	679218-1	STRIPPER WIRE STOP ASSY	20							
1	1	-	-	B	458949-1	STRIPPER	19							
1	1	1	-	B	1-690518-9	HOLDER, TERMINAL	18							
							17							
1	1	1	-	B	318563-1	GUARD, CHIP, FRONT	16							
							15							
							14							
							13							
1	1	1	-	A	5-22280-0	SPRING, SHEAR	12							
1	1	1	-	B	690461-1	STOP, SHEAR	11							
1	1	1	-	C	690459-1	HOLDER, SHEAR (FRONT)	10							
1	1	1	-	C	462006-1	SHEAR, FLOAT (FRONT)	9							
1	1	1	-	C	7-805887-9	ANVIL	8							
1	1	1	-	C	5-240641-8	SPACER, DEPRESSOR (REAR)	7							
							6							
1	1	1	-	C	1-455889-4	DEPRESSOR, SHEAR (FRONT)	5							
1	1	1	-	B	2-238011-3	SPACER, BLOCK CRIMPER	4							
1	1	1	-	C	5-683453-2	CRIMPER, INSULATION	3							
1	1	1	-	C	455888-2	SPACER, CRIMPER	2							
1	1	1	-	C	2-456401-8	CRIMPER, WIRE	1							

QTY	REF	REF	REF	REF	REF	REF	REF	REF	REF	REF	REF	REF	REF	REF
-3	-2	-1	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO	REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION)						
QTY RECD PER ASSY								PARTS LIST						
DIMENSIONS IN INCHES. DO NOT SCALE PRINT. TOLERANCES UNLESS OTHERWISE SPECIFIED:								MATERIALS						
2 PLC DEC ± -								DR B.HIGMAN						
3 PLC DEC ± -								CHK -						
4 PLC DEC ± -								REL -						
ANGLES ± -								17DEC02 APP T.ELBIN						
SURF TEXTURE: ✓								AMP Tyco Electronics Harrisburg, PA 17105-3608						
REMOVE BURRS, BREAK SHARP EDGES R.015 MAX								NAME SIDE FEED HDM APPLICATOR MACHINE REF MINI APPL						
SCALE -								DWG NO 1385531 SHEET REV 1 OF 1 A						
CUSTOMER AND ASSEMBLY DRAWING												RESTRICTED TO		